

Work Order ID 84524

May-15-12 10:40:57 AM

\*84524\*

Page 1

Item ID: D412-742-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Replacement Float Skidtube

Stop \*NS2\*

Start Date: 15/05/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 06/06/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/05/15 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3391

I

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

If D412-742-041 is a W/O on it's own,  
Photocopy bluefile and create labels per PPP D412-742-041 CHG005

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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**\*84524\***

Page 2

Item ID: D412-742-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Replacement Float Skidtube

Stop **\*NS2\***

Start Date: 15/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 06/06/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Assemble as per dwg	0.00							
<b>*110*</b>	HandFinishing								
Hand Finish	Memo	0.00							
Hand Finishing	1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins. A/RSikaflex-241/-291 <u>11121469</u> Expiry date: <u>13/03</u>								
	2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex. A/RSikaflex-241/-291 <u>11121469</u> Expiry date: <u>13/03</u>								
	3-Remove "T" pins once sikaflex is dry.								
	4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser. A/RLPS Procyon <u>11114596</u>								
120	QC5- Inspect part completeness to step on W/O	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

1x 6 24 11/06/12

5/26/12

W/O:		WORK ORDER CHANGES					
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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Float Skidtube

Start Date: 15/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 06/06/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

**\*130\***

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-742-041

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

140

0.00

**\*140\***

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

JPP 84509

2/12/12

MCS 12/06/12

MUF  
12-06-12

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

May-15-12 10:41:00 AM

Page 1

Work Order ID: 84524

**\*84524\***

Parent Item: D412-742-041

**\*D412-742-041\***

Parent Item Name: Replacement Float Skidtube

Start Date: 15/05/2012

Required Date: 06/06/2012

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev A 05.10.13 New Issue KJ/JLM  
 IPP Rev 06.02.13 ECN 773 dwg @ rev.D EC  
 IPP Rev:C 07-05-28 As per Rev F JLM  
 IPP rev.D 07.11.01 ecn 1053p EC  
 IPP rev E 07.11.27 ecn 1072 EC verified by:DD  
 IPP Rev:F 08-09-08 ecn 08-510 DD verified by:EC IPP Rev:G  
 10.02.24 as per ECN10-514 DD verified by: EC IPP Rev:H 11.11.01 as  
 per DSI9517 REV.B DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3591-1		Manufactured	No			110	Each	104.0000	2	2			
---------	--	--------------	----	--	--	-----	------	----------	---	---	--	--	--

**\*D3591-1\***

Bushing

\*\*

### Location

### Loc Qty

### Loc Code

FP

5

80377

4

82027

1

ST055

99

57350

1

83237

98

D3391-011

Manufactured No

110

Each

0.0000

1

1

**\*D3391-011\***

Fwd Tube Assembly

\*\*

384513 (x1) 12/06/13

D3391-013

Manufactured No

110

Each

0.0000

1

1

**\*D3391-013\***

Mid Tube Assembly

\*\*

384515 (x1) 12/06/13

D3391-015

Manufactured No

110

Each

0.0000

1

1

**\*D3391-015\***

Aft Tube Assembly

\*\*

384518 (x1) 12/06/13

used on  
-013 84515- MF 12-06-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 2

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Parent Item: D412-742-041

**\*D412-742-041\***

Parent Item Name: Replacement Float Skidtube

Start Date: 15/05/2012

Required Date: 06/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

110

Each

1,969.000

24

24

**\*AN3C4A\***

BOLT

\*\*

92 12/06/13

Location

Loc Qty

Loc Code

ST350

1969

120187

63

120521

28

120769

38

121205

1000

121556

840

✓ 24

AN3C6A

Purchased

No

110

Each

495.0000

10

10

**\*AN3C6A\***

BOLT

\*\*

92 12/06/13

Location

Loc Qty

Loc Code

FP001

1

111982

1

ST351

494

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

21

120423

3

120693

202

121682

200

✓ 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Work Order ID: 84524

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Parent Item: D412-742-041

**\*D412-742-041\***

Parent Item Name: Replacement Float Skidtube

Start Date: 15/05/2012

Required Date: 06/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C7A Purchased No

110 Each 160.0000 4 4

**\*AN3C7A\***

BOLT

\*\*

yl 12/06/13

Location

Loc Qty

Loc Code

ST351

160

113149

14

116169

1

117313

10

117619

12

117688

6

119749

1

120731

16

121185

50

121541

50

yl

AN960C10L

NAS1149C0332

Purchased No

110 Each 0.0000 38 38

**\*AN960C10L \***

washer

\*\*

(x38) yl 12/06/13

MS27039C4-12

Purchased No

110 Each 19.0000 4 4

**\*MS27039C4-12\***

SCREW

\*\*

yl 12/06/13

Location

Loc Qty

Loc Code

FP002

19

114221

19

D3672-3

Manufactured No

110 Each 5.0000 4 4

**\*D3672-3\***

Phenolic Washer

\*\*

yl 12/06/13

Location

Loc Qty

Loc Code

ST060

5

83238

5

B84361

yl

May-15-12 10:41:00 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 84524

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Parent Item: D412-742-041

**\*D412-742-041\***

Parent Item Name: Replacement Float Skidtube

Start Date: 15/05/2012

Required Date: 06/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN960C416L

Purchased No

110

Each

0.0000

4

4

**\*AN960C416I \*** *YUAS 1149 CG 432R*

WASHER

\*\*

*11/21/255 (x4) M 11/06/12*

D4095-041

Manufactured No

110

Each

4.0000

1

1

**\*D4095-041\***

Wearplate Assembly

\*\*

*M 11/06/12*

Location

Loc Qty

Loc Code

FP001

4

81623

4

*X1*

D4095-043

Manufactured No

110

Each

5.0000

1

1

**\*D4095-043\***

Wearplate Assembly

\*\*

*M 11/06/12*

Location

Loc Qty

Loc Code

FP001

5

78995

1

81624

4

*X1*

D4095-045

Manufactured No

110

Each

6.0000

1

1

**\*D4095-045\***

Wearplate Assembly

\*\*

*M 11/06/12*

Location

Loc Qty

Loc Code

FP

5

81625

5

FP001

1

77737

1

*1384081*

*X1*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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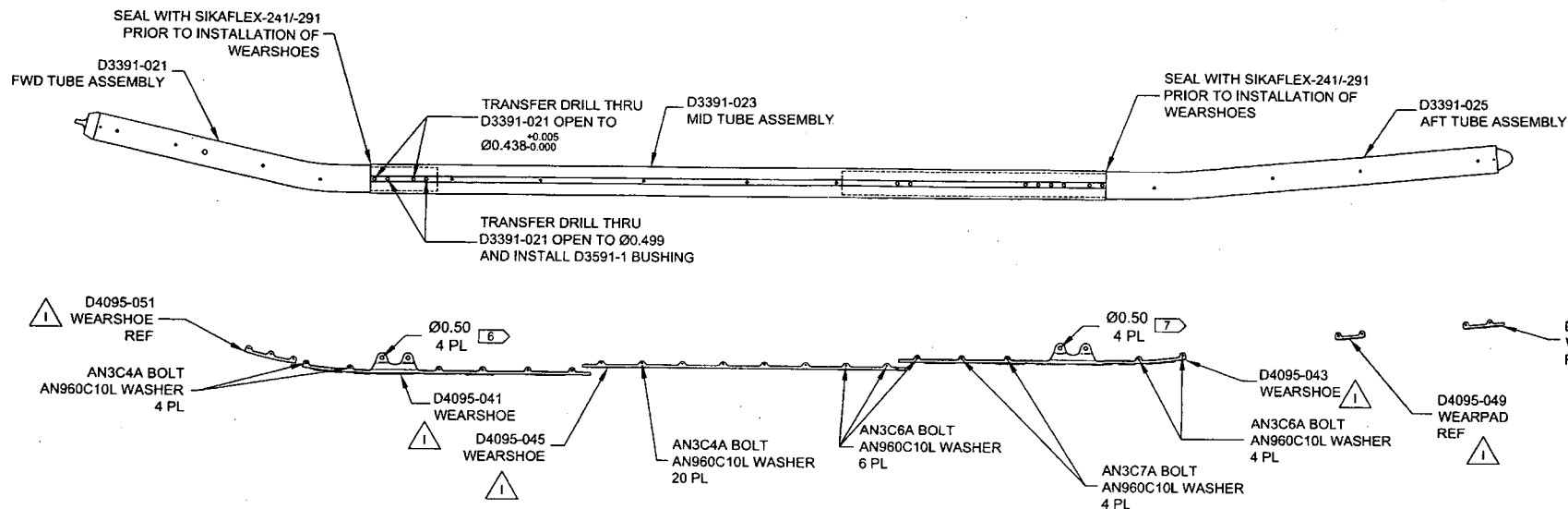
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**NOTE:** Date & initial all entries



2524



**D3391-043 ASSEMBLY**

**D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY -043	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

**GENERAL NOTES**

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
- 3) AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 7) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 8) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

RELEASED  
2011-11-04

DESIGN		PH	DART AEROSPACE USA, INC	
DRAWN		XDF	KENT, WA	
CHECKED			DRAWING NO.	REV. 1
MFG. APPR.			D3391	SHEET 2 OF 8
APPROVED			TITLE	SCALE
DE APPR.			412 FLOAT SKIDTUBE	NTS
DATE		11.10.13	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

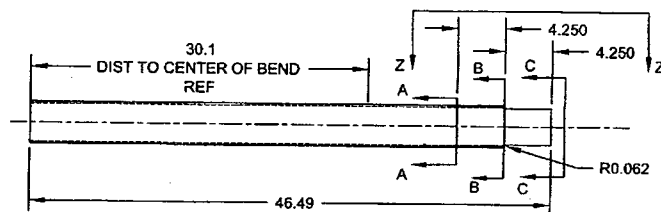
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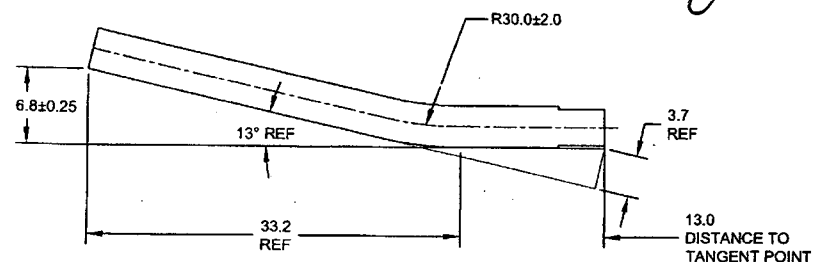
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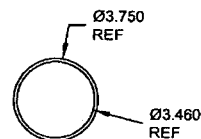
**NOTE:** Date & initial all entries



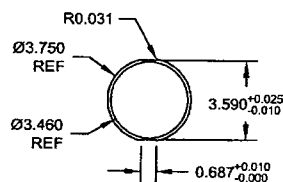
**D3391-1 CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



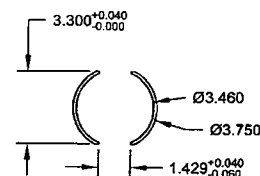
**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



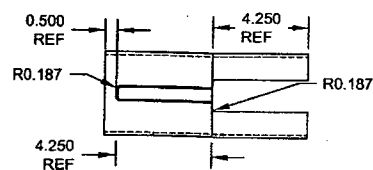
**SECTION A-A**  
SCALE 2X



**SECTION B-B**  
SCALE 2X



**SECTION C-C**  
SCALE 2X



**VIEW Z-Z**  
SCALE 2X

RELEASED  
2011-11-04

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO. D3391	REV. I
MFG. APPR.			SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

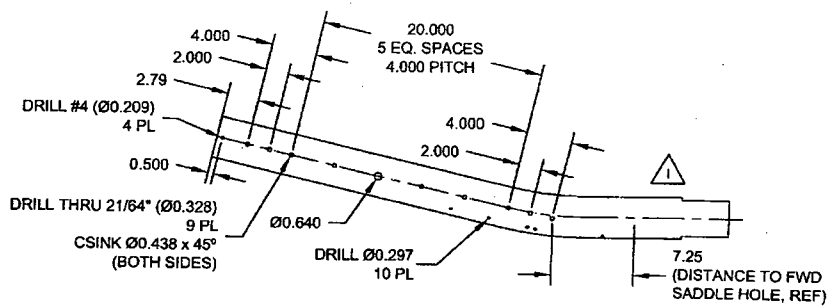
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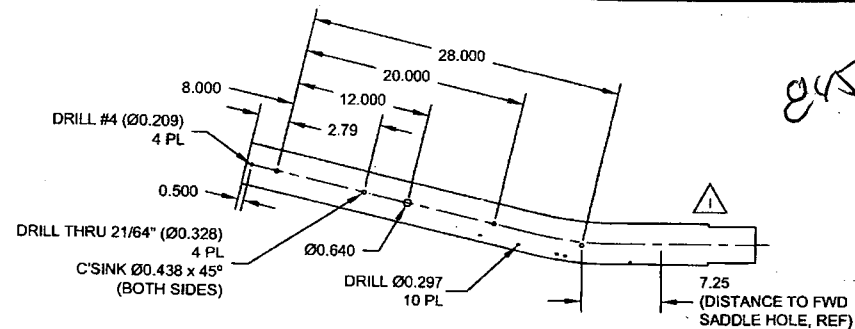
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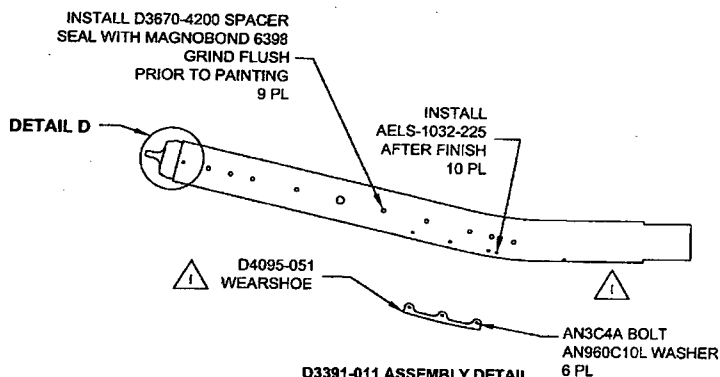
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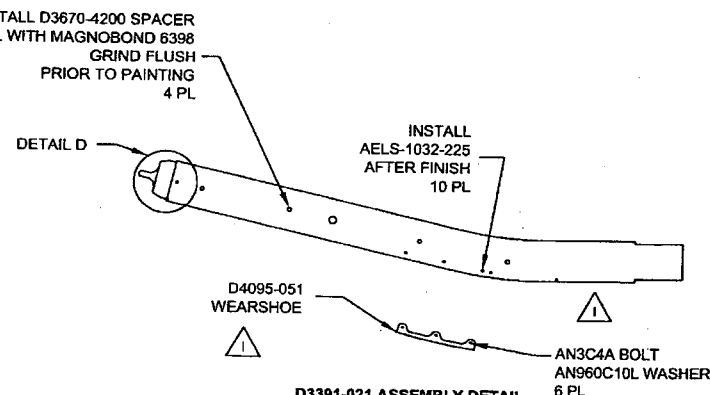
**D3391-011 DRILLING DETAIL**



**D3391-021 DRILLING DETAIL**



**D3391-011 ASSEMBLY DETAIL**



**D3391-021 ASSEMBLY DETAIL**

**D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST**

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D3401-041	TOW CAP
9	4	D3670-4200	SPACER
4	4	D3672-1	WASHER
1	1	D4095-051	WEARSHOE
1	1	D6013-047	FWD TUBE
10	10	AN3C4A	BOLT
10	10	AN960C10L	WASHER
10	10	AELS-1032-225	INSERT

SEAL WITH  
SIKAFLEX-241/-291

D3401-041  
TOW CAP

**DETAIL D**  
SCALE 2X

AN3C4A BOLT  
D3672-1 WASHER  
AN960C10L WASHER  
4 PL

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2011-11-04

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3391	SHEET 4 OF 8
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**Dart Aerospace Ltd**

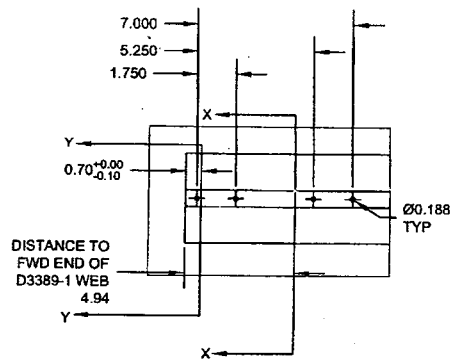
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

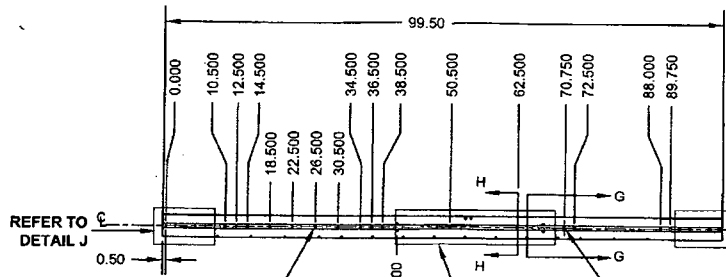
**NOTE:** Date & initial all entries

8V524



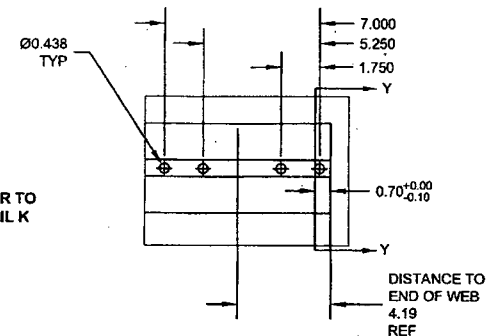
DETAIL J  
SCALE 4X

DRILL THRU 21/64" (Ø0.328)  
CSINK Ø0.438 X 45° (BOTH SIDES)  
12 PL

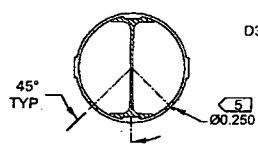


D3391-013 ASSEMBLY DETAIL

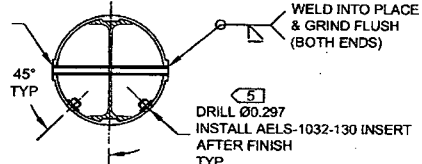
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DETAIL K



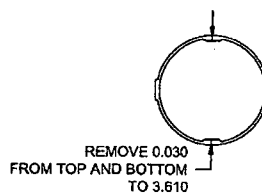
DETAIL K  
SCALE 4X



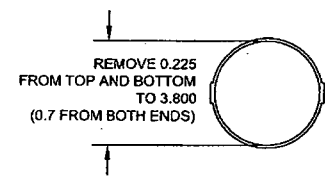
SECTION G-G  
SCALE 5X



SECTION H-H  
SCALE 5X



SECTION X-X  
SCALE 5X



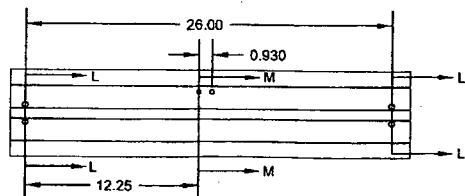
SECTION Y-Y  
SCALE 5X

D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

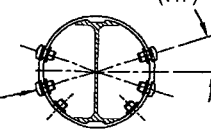
D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

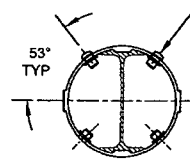


DETAIL E  
SCALE NONE

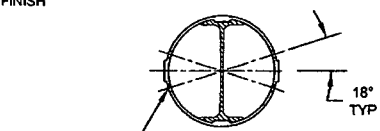
DRILL Ø0.391  
INSTALL ALS4-428-165 INSERT  
MS27039C4-08 SCREW  
D3672-3 WASHER  
AN960C416L WASHER  
AFTER FINISH  
4 PL



SECTION L-L  
SCALE 5X



SECTION M-M  
SCALE 5X



SECTION LL-LL  
SCALE 5X

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DESIGN	PH	DART AEROSPACE USA, INC	
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MFG. APPR.		D3391	SHEET 5 OF 8
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

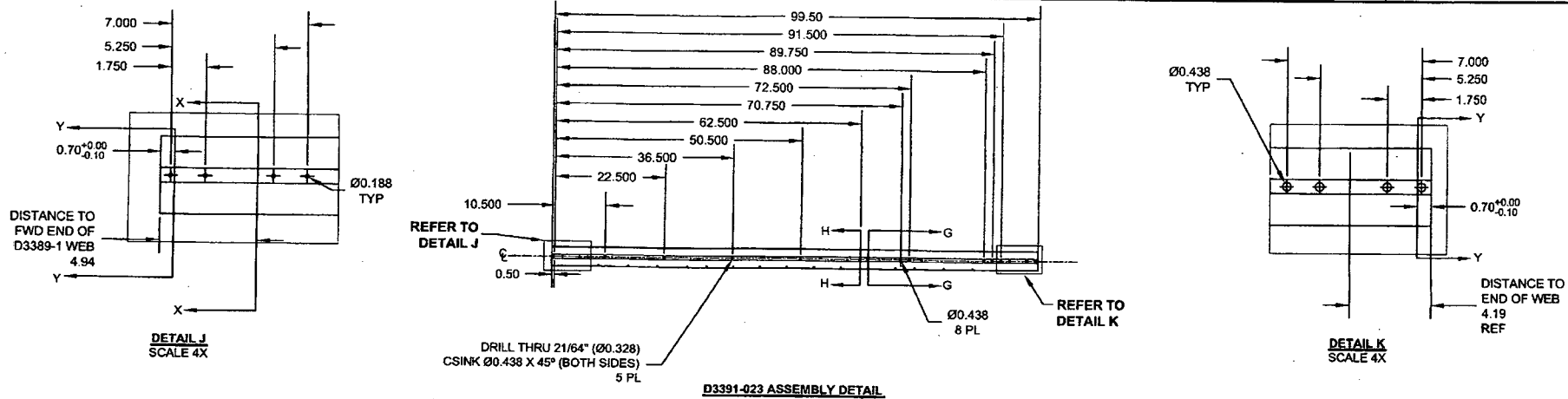
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

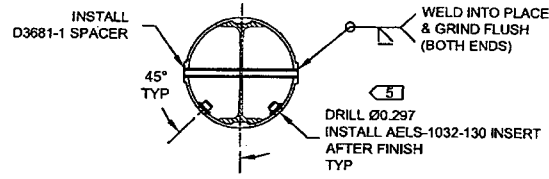
**NOTE:** Date & initial all entries



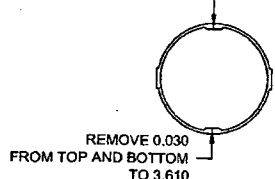
84524



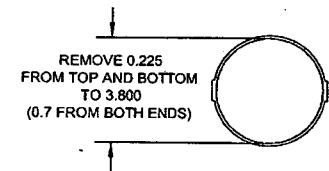
SECTION G-G  
SCALE 5X



SECTION H-H  
SCALE 5X



SECTION X-X  
SCALE 5X



SECTION Y-Y  
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY -	PART NUMBER	DESCRIPTION
023		
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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2011-11-04

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

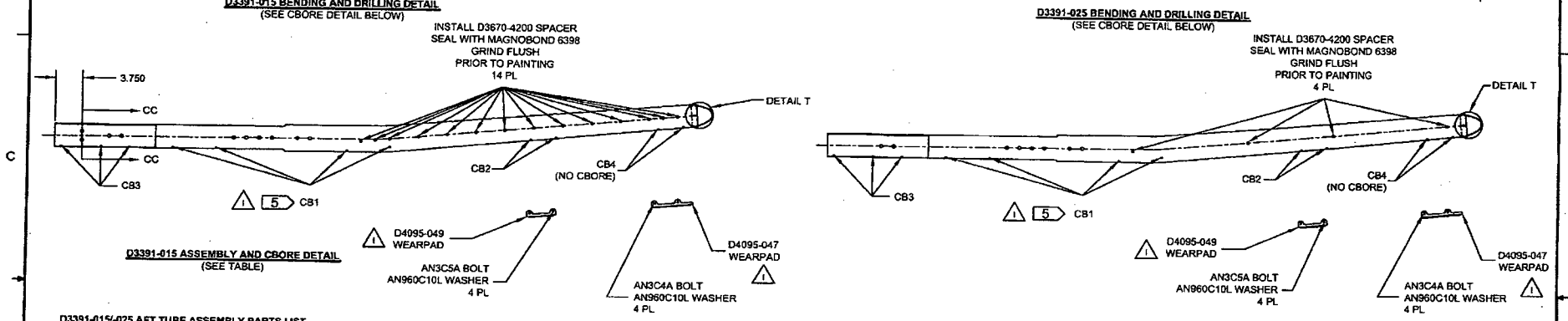
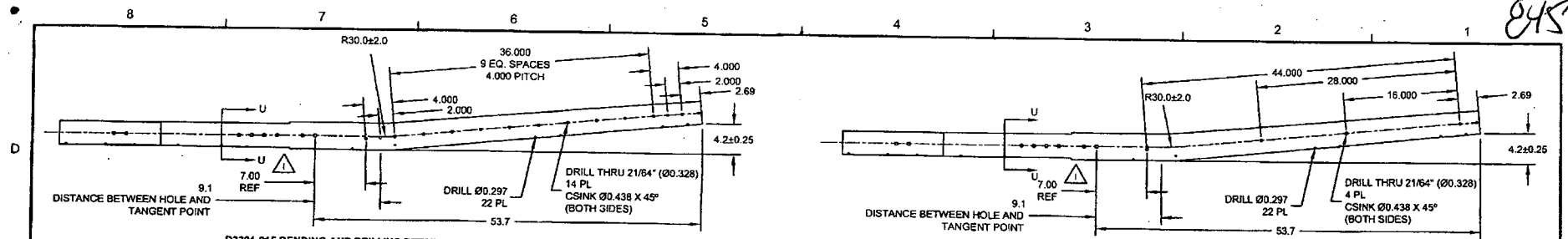
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

84524

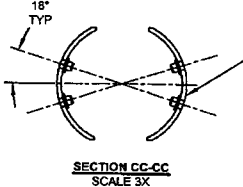
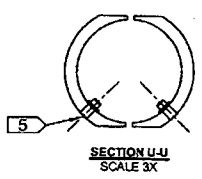


**D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST**

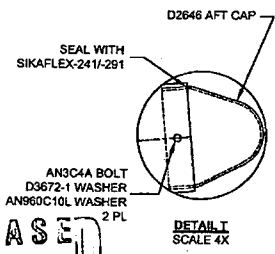
QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D2646	AFT CAP
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
1	1	D4095-049	WEARPAD
1	1	D4095-047	WEARPAD
1	1	D6014-090	AFT TUBE
14	14	AELS-1032-130	INSERT
8	8	AELS-1032-225	INSERT
4	4	ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER

CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND  
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	8	8	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130



DRILL Ø0.391  
CBORE Ø0.516 X 0.040 DEEP  
INSTALL ALS4-428-165 INSERT  
4 PL



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2011-11-04

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MFG. APPR.		D3391	SHEET 8 OF 8
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries